

FIG. 1

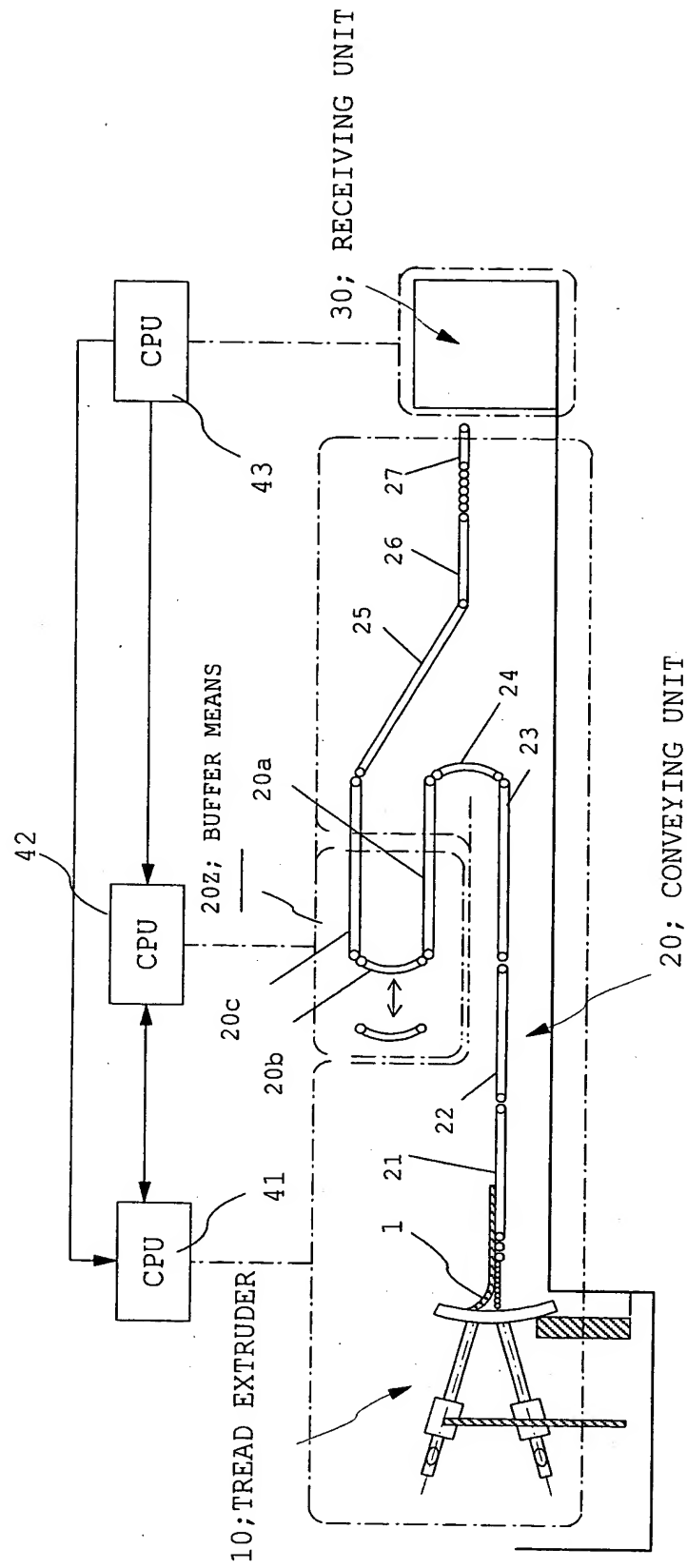


FIG. 2

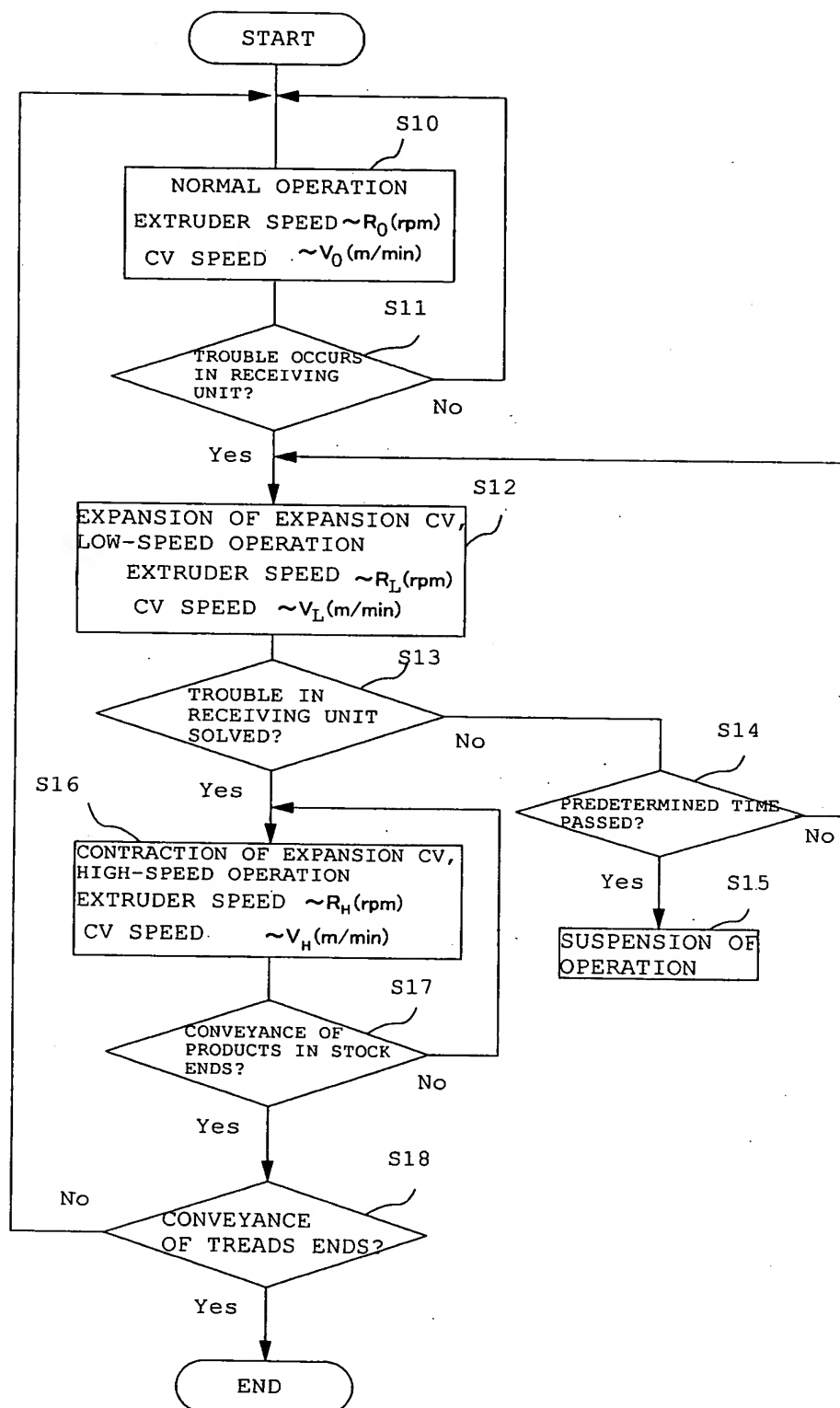


FIG. 3

EXTRUDER SPEED TABLE

CV SPEED (m/min)	EXTRUDER #1 (rpm)	EXTRUDER #2 (rpm)
0.5	23	15
0.6	26	17
⋮	⋮	⋮
⋮	⋮	⋮
⋮	⋮	⋮
⋮	⋮	⋮
20.0	1000	950

FIG. 4

SIZE RECIPE

	PARAMETER	
AT THE TIME OF INCREASING SPEED	RESPONSE DELAY OF EXTRUDER SPEED	35 (0.1%)
	ATTENUATION TIME	33 (sec.)
AT THE TIME OF REDUCING SPEED	RESPONSE DELAY OF EXTRUDER SPEED	20 (0.1%)
	ATTENUATION TIME	15 (sec.)

FIG. 5

